

19-7804



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3290-1
Job Sheet 201882



Part No: D3290-1

Job Qty: 12 pcs

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/19

Job Tracking No:

Due Date: 10/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		10/28/19	0.17	2.51	Waterjet - Flow		JRB 10/22/19
120	QC 8	12 pcs		10/28/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Handfinish - 1-1 Chemical-B4B	12 pcs		10/28/19	0.00	0.82	Handfinish - 1 - 1 - B4B		BEB 19-10-22
							Handfinish - 1 - 2 -		

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DART
AEROSPACE

Container No: S224896

Part: D3290-1

Job No: 201882

Serial No/Batch: S224896

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/22/19

PRIORITY

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

					B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
135 QC 7	12 pcs	10/28/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	

					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
140	Powdercoat - 1 White GI(A)- B4B <i>M. 21186</i>	12 pcs	10/28/19	0.00 0.58	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
150	QC 3	12 pcs	10/28/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Packaging 3-1 - Stock - B4B <i>3</i>	12 pcs	10/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

*REL 19 10-23**START: 7:15 O.V.T: 320° FINISH: 7:45**OCT 23 2019 DAS 40 9-89**ST 432*

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 3 pcs	10/28/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 432
				QC 21 - SA - 70	
				QC 21 - SA - 53	OCT 23 2019
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Chemical Conversion Coat per QSI005 4.1) 135 - (QC7-Inspect Chemical Conversion Coat) 140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 150 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.063	6061-T6 .063 Sheet	45 sf (3.75 ea)	100-Waterjet - Flow - 1	S190194	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M6061T6S.063	45	320	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches $\pm$ 0.030	29.030 28.970	29	
2	Window Frame	14.000inches $\pm$ 0.030	14.030 13.970	14	
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170	0.171	
4	Window Frame	1.500inches $\pm$ 0.030	1.530 1.470	1.505	
5	Window Frame	1.110inches $\pm$ 0.030	1.140 1.080	1.112	
6	Window Frame	10.100inches $\pm$ 0.030	10.130 10.070	10.100	
7	Window Frame	18.500inches $\pm$ 0.030	18.530 18.470	18.508	
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053	0.063	
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970	3.000	
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470	4.502	
11	Window Frame	0.257inches + 0.006 - 0.001	0.263 0.256	0.256	
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580	13.611	

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Entered: JEDate: Dec 31/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7804Route update only ☐

Job: <u>D3290-1</u>		DISPOSITION		DEPARTMENT/PROCESS																																													
Part No. <u>201882</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐																																													
Date: <u>OCT 22 2019</u>	Sequence #: <u>120</u>	QTY Affected: <u>1084</u>		MRB (QS1042) DAS 9 9-89 <u>19.11.21</u>																																													
Description Work Order Deviation		Disposition		Completed By <u>OC 1922 2019</u>																																													
<u>- part got stuck in deburring machine</u> <u>- got grinded down and bent out of tolerance</u>		<u>- scrap more place</u>		Lead hand / Supervisor <u>JE</u> <u>19/10/28</u>																																													
Root Cause		QC / QA Coordinator DAS 9 9-89 <u>19.11.21</u>																																															
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